

Work Order ID 57617

April 12, 2010 8:23:44 AM

Page 1

Item ID: D2572

Accept

Revision ID:

Item Name: Saddle, Fwd In 205

Start Date: 16/04/2010 Start Qty: 8.00

Required Date: 16/04/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. DJP

Double check by: SB

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

DJP
10/04/14

7

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

DJP
10/04/18

8

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Page 2

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Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

DT 10/04/18

8

0

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

SB 10/04/19

8

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

MS 10/04/20

8

0

HandFinish

Memo

0.00

Hand Finishing

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Page 3

Item ID: D2572

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Setup Start



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Stop



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Start Date: 16/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



1114207

2744 10/04/21

0

0

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:00am
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30am

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8

BR 10-4-21

170

Identify as per dwg & Stock Location:

0.00



433

Packaging

Memo

0.00

Packaging

CU 11/4/22 8

Work Order ID 57617

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Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 16/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/26 *[Signature]*
MF 10-4-22

Picklist Print

April 12, 2010 8:23:44 AM

Page 1

Work Order ID: 57617



Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 16/04/2010

Required Date: 16/04/2010

Comments: IPP: 11.02.10.021 (Re-format; Change to Dwg Rev. D & incorporated D2572) KJ:1

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	86.0000	8.0000			



Saddle Billet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT46

86

46411

86

8
DJA
10/04/14

DART AEROSPACE LTD	Work Order: 57617
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.747	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.004	8.004		
F	0.490	0.510		0.503	0.501	0.501	0.505		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.501	0.501	0.500	0.502		
J	1.174	1.184		1.178	1.179	1.179	1.178		
K	0.558	0.578		0.573	0.569	0.569	0.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.874	3.874	3.874		
P	0.115	0.135		0.125	0.124	0.124	0.125		
Q	0.115	0.135		0.125	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.252	0.253	0.252		
S	0.115	0.135		0.129	0.129	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.234	0.232	0.233		
W	0.115	0.135		0.130	0.129	0.129	0.130		
X	0.307	0.312		0.309	0.310	0.309			
Y	0.760	0.765		0.763	0.763	0.763			
Z	0.352	0.372		0.364	0.361	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.628	0.628	0.6255		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.248	0.248	0.248		
AE	1.375	1.395		1.386	1.3885	1.389	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.245	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.249	0.246	0.247		
AI	2.000	2.020		2.002	2.003	2.006	2.006		
AJ	0.023	0.043		0.033	0.033	0.033			

Accept/Reject

Measured by: DJT	Audited by: ST
Date: 10/04/17	Date: 10/04/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	57617
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

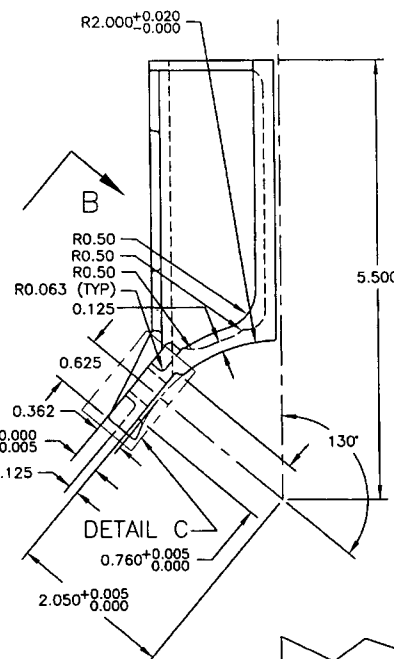
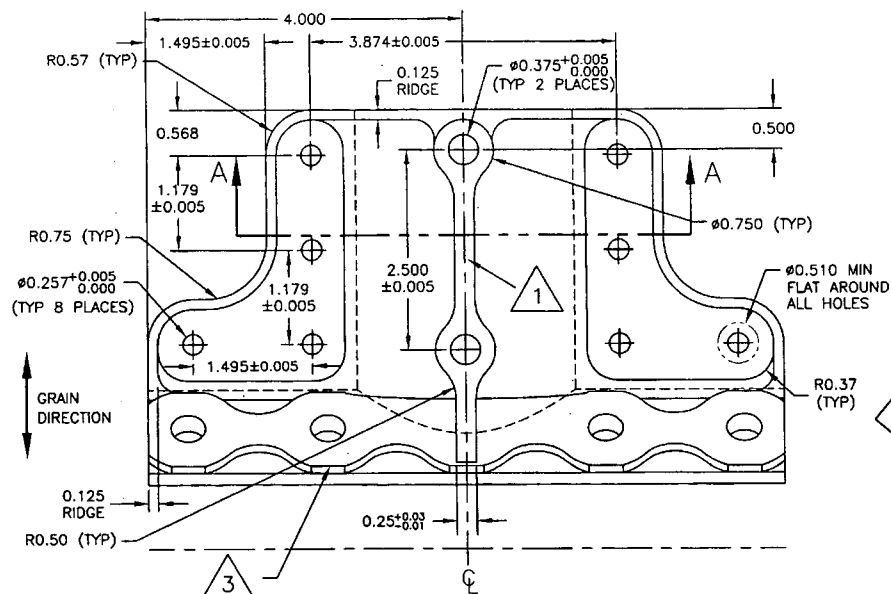
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.500	0.496	0.499	0.498		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.501	0.500	0.502	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.568	0.571	0.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.124	0.125	0.124	0.125		
Q	0.115	0.135		0.125	0.130	0.130	0.130		
R	0.240	0.260		0.253	0.253	0.258	0.253		
S	0.115	0.135		0.132	0.130	0.135	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.236	0.235	0.235		
W	0.115	0.135		0.129	0.128	0.127	0.127		
X	0.307	0.312		0.3105	0.310	0.310	0.310		
Y	0.760	0.765		0.763	0.763	0.763	0.763		
Z	0.352	0.372		0.3615	0.361	0.359	0.359		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.629	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.244	0.242		
AE	1.375	1.395		1.3885	1.390	1.3885	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.249	0.248	0.249	0.250		
AI	2.000	2.020		2.003	2.005	2.004	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>DT</i>	Audited by: <i>SP</i>
Date: 10/04/18	Date: 10/04/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

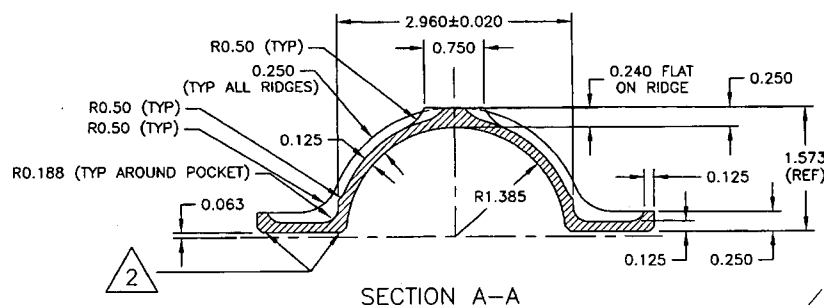
05.12.06



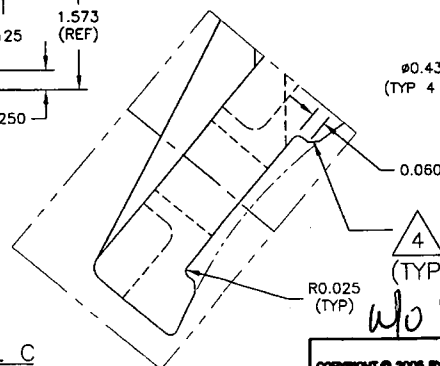
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

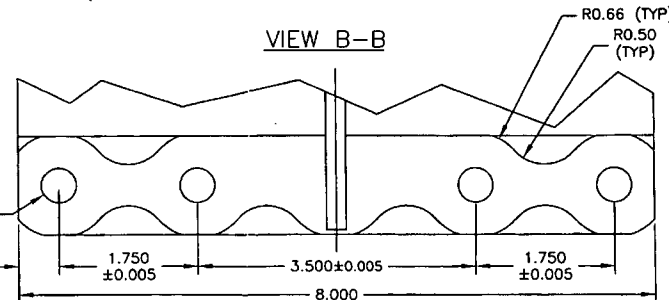


SECTION A-A



DETAIL C
SCALE 2:1

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		SCALE 2:3

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DART DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO. D2572
REV. E
SHEET 1 OF 1